

Date:

Wednesday, 3/7/2007 3:52:58 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CHAFING SHIELD
Job Number	: 31071		
Estimate Number	: 11138		
P.O. Number	: <i>N/A</i>	Part Number	: D31901
This Issue	: 3/7/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3190 REV A
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 28998	Drawing Revision	: A
	Type : MACHINED PARTS	Material	: <i>N/A</i>
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	: <i>07.03.07</i>	Qty:	12 Um: Each
Comment	: Est. A 03/05/26 New issue KJ/RF		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S25GA 304/316 .020" Sheet



Comment: Qty.: 0.2261 sf(s)/Unit Total: 2.7128 sf(s)

304/316 SS .020" Sheet

Material: AISI 304/316 SS 0.020" thick sheet

; (M304S25GA)

Batch:

*11 103 678 x 2**11 102 376 x 10**FF 07-04-09 12*

2.0 SHEAR SHEAR



Comment: SHEAR

Cut blank: 9.25" x 3.13"

Grind corner as per Dwg D3190

Deburr

Roll as per Dwg D3190

FF 07-05-03 12

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/03 (12)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/05/03 (12)

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/04

Job Completion

*07/05/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

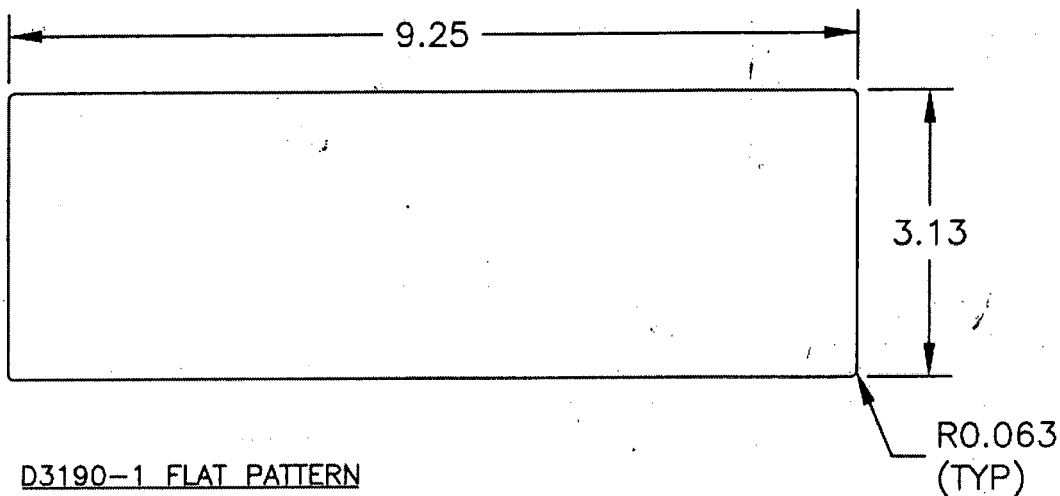
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

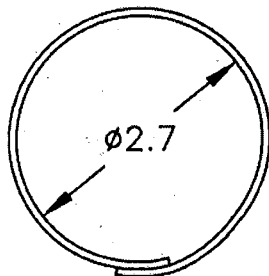


DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	

RELEASED
03.05.22 #



D3190-1 FLAT PATTERN



D3190-1 ROLLING DETAIL
NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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NO. 31041

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